

# KR II Series

Thyristor-controlled CO<sub>2</sub>/MAG Welding MachineCO<sub>2</sub>/  
MAG

200 KR2



350 KR2



500 KR2

## Non-remote control cable design

- By carrying the remote controller on the wire feeder and improvement of control circuit, the original two pieces of cable was integrated to one piece. This realized light weight, improved mobility and decreased wire breaking trouble.

## Convincing high reliability

- High insulation strength(Class H), high temperature resistance and good dust proof structure are adopted in main transformer and reactor.
- IP(International Protection) class of enclosure is IP21S and it effectively prevents the affection and interference of the main circuit to the control circuit. And moisture-proof, drip-proof and dust-proof structure enables the operation under adverse circumstances. The welding voltage can automatically match the welding current. The fine-tuning of voltage can be done as per individual operational habit.

The special patented technology preventing the damage of main transformer further improves the safety performance and reliability of the machine.

## Good welding performance

- KR2 adopts the special control circuit which realizes low spatter welding in short circuit transfer and spray transfer of CO<sub>2</sub>/MAG welding.
- The arc starting circuit ensures high rate of success of arc start, which reaches to almost 100% under any operating mode within the technical specifications. It is also possible to be equipped with various automatic welding systems.

## Individual and Simple Unitary mode

- When Simple Unitary mode is selected and welding current is set by the current adjustment knob on the remote controller, almost corresponding welding voltage is automatically set. Fine-tuning of voltage is also possible.

## Specifications

Model		YD-200KR	YD-250KR	YD-350KR	YD-400KR	YD-500KR
Control method	-	Thyristor				
Input power source frequency	Hz	50 / 60				
Rated input capacity	kVA/kW	7.6 / 6.5	9.5/7.9	18.1 / 16.2	21/19	31.9 / 28.1
Rated duty cycle	%	60	60	50	60	60
Output current range	A	50~220	50~250	60~380	60~400	60~550
Output voltage range	V	16.5~25	15~27	17~33	16~39	17~41.5
Crater current range	A	50~220	50~250	60~380	60~400	60~550
Crater voltage range	V	16.5~25	15~27	17~33	16~39	17~41.5
Method of welding	-	Individual/Unitary				
Enclosure protection class	-	IP21S				
Insulation class	-	H				
Cooling mode	-	Forced air cooling				
Applicable welding wire type	-	Solid / FCW				
Applicable welding wire diameter	mm	Solid 0.8/1.0/1.2			Solid 1.2/1.4/1.6	
	mm	FCW 0.8/1.0/1.2			FCW 1.2/1.4/1.6	
Overall dimensions(W×D×H)	mm	376×675×747			436×675×762	
Mass	kg	89	117	117	158	158
Wire feeder		YW-20KB3	YW-25KB3	YW-35KB3	YW-40KB3	YW-50KB3
Applicable welding wire diameter	mm	0.8/1.0/(1.2)			1.2/1.6	
Length of cable	m	1.8				
Welding torch		YT-20CS3	YT-35CS4	YT-35CS4	YT-40CS4	YT-50CS4
Rated current	A	200	350	350	400	500
Applicable welding wire diameter	mm	0.8/1.0/(1.2)	(0.8)/1.0/1.2	(0.8)/1.0/1.2	1.2/1.6	1.2/1.6
Length of torch cable	m	3				
Gas regulator		YX-25CD1				

## Various kinds of protection functions, convenient functions and good expandability.

- Overheat protection
- Under-voltage protection
- Output over-current protection
- Lighting-proof circuit
- Adjustable burn-back time
- Pre-flow on-off selection
- Current detection terminal for peripheral equipment